

Work Order ID 77602

77602

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Tuesday, December 13, 2011 2:47:52 PM

Item ID: D2804-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 12/13/2011 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/5/2012 Req'd Qty: 4.00 *4* Customer:

Reference:

Approvals: Process Plan: H Date: 12-13-11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2804	Rev C

100 0.00

100 FLOW WATER JET 0.00 12-1-30 (8)

Waterjet Memo 1-Cut as per File D2804-1-2_BLANK

FLOW CNC Waterjet Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

110 0.00

110 HAAS CNC VERTICAL MACHINING #1 0.00 OK/12-01-31 (+8)

HAAS 1 Memo Machine as per folio FA103

HAAS CNC vertical machine #1

120 0.00

120 QC2- Inspect parts off machine FAI/FAIB 0.00 OK/12-01-31 (+8)

QC Memo

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		EP 12-2-2		8	1		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

8x4 m-12/02/02

8 12-2-2

Dart Aerospace Ltd

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 Required Date: 1/5/2012 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date: 12/02/08 (8)

Handwritten signature and date: M.C.J. 12/02/08

Handwritten signature and date: M.C.J. 12/02/08 (8)

Dart Aerospace Ltd

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Picklist Print

Tuesday, December 13, 2011 2:47:56 PM

Page 1

Work Order ID: 77602

77602

Parent Item: D2804-2

D2804-2

Parent Item Name: Bracket

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A00.11.06New IssueEC
IPP B06.05.30 Blanks on wtjetEC
IPP Rev:C As per Rev C 06-11-09 JLM
IPP Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.500X10.00
0

Purchased

No

f

24.1000

3

M6061T6B0 500X10 000

**

B12-1-30

6061-T6 Bar .500 x 10.00

Location

Loc Qty

Loc Code

MAT004

24.1

119513

24.1

M120421

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	77602
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.1225	✓		caliper	
0.125	+/-0.010	.123	✓		"	
R0.125	+/-0.010	.125	✓		rad gauge	
0.250	+/-0.010	.248	✓		caliper	
0.250	+0.000/-0.005	.247	✓		"	
0.875	+0.000/-0.001	.8744	✓		micrometer	
R0.062	+/-0.010	.062	✓		rad gauge	
Ø0.757	+0.005/-0.000	.759	✓		caliper	
R0.625	+/-0.010	R.625	✓		R-b	
12.304	+/-0.005	12.306	✓		caliper	
Ø0.507	+0.000/-0.001	.507	✓		caliper	
0.437	+0.000/-0.001	.437	✓			
0.608	+0.000/-0.001	.608	✓			
Ø0.191	+0.005/-0.000	.193	✓		caliper	
1.420	+0.001/-0.001	1.420	✓			
0.250 deep	+/-0.010	.248	✓		depth gauge	
6.933	+/-0.005	6.936	✓		caliper	
7.578	+/-0.005	7.582	✓		"	
0.500	+/-0.010	.501	✓		"	

Measured by: KJ/JLM	Audited by: RE	Prototype Approval:	N/A
Date: 12-01-31	Date: 12-2-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	RE

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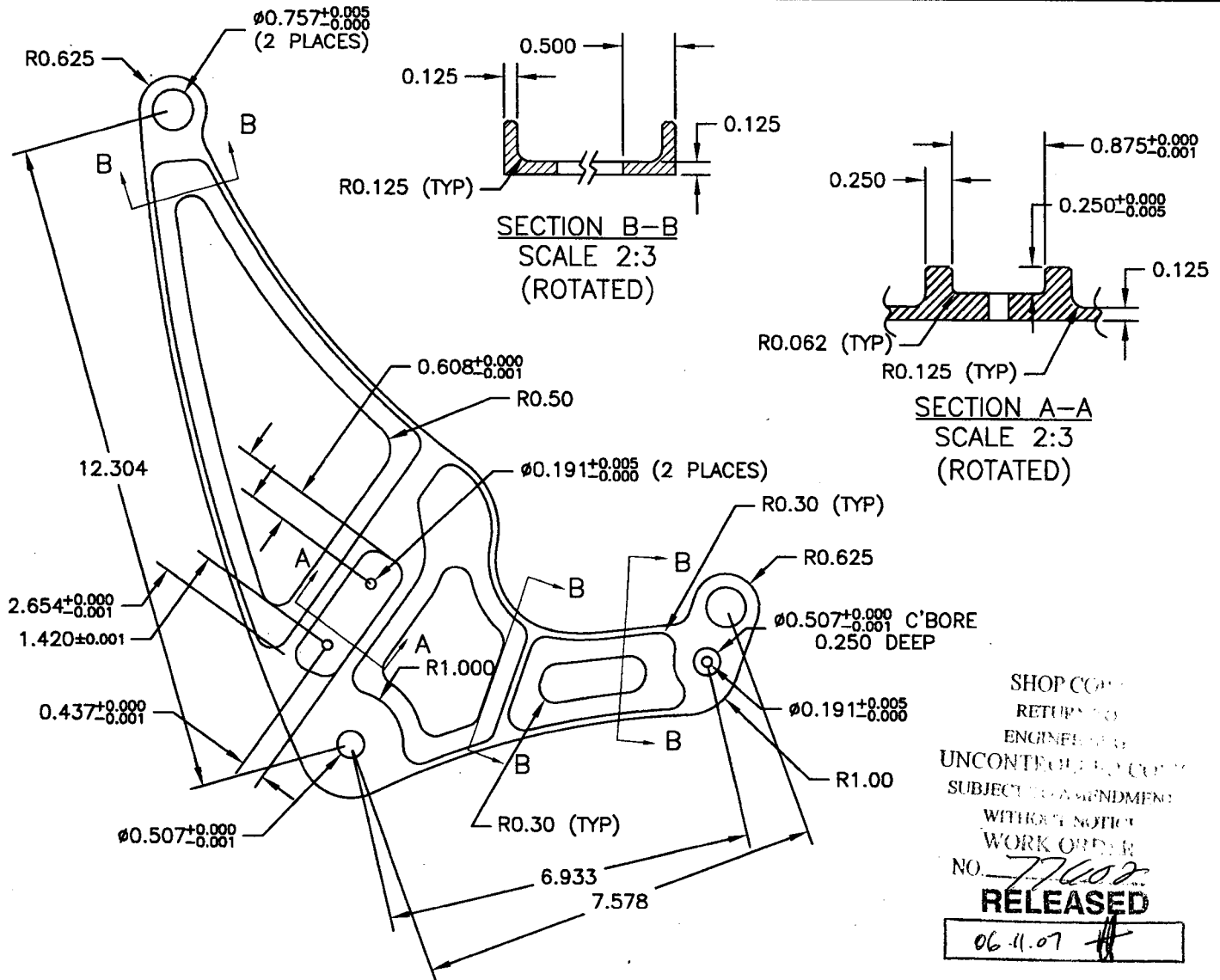
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN CP		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. REV. C D2804 SHEET 1 OF 2	
DATE 06.10.16		TITLE SCALE STA 155 BRACKET 1:3			
A	00.11.07		NEW ISSUE		
B	04.11.22		ADD CUTOUTS & -043/-044		
C	06.10.16		CHANGE GEOM. TO ADD CLEARANCE		

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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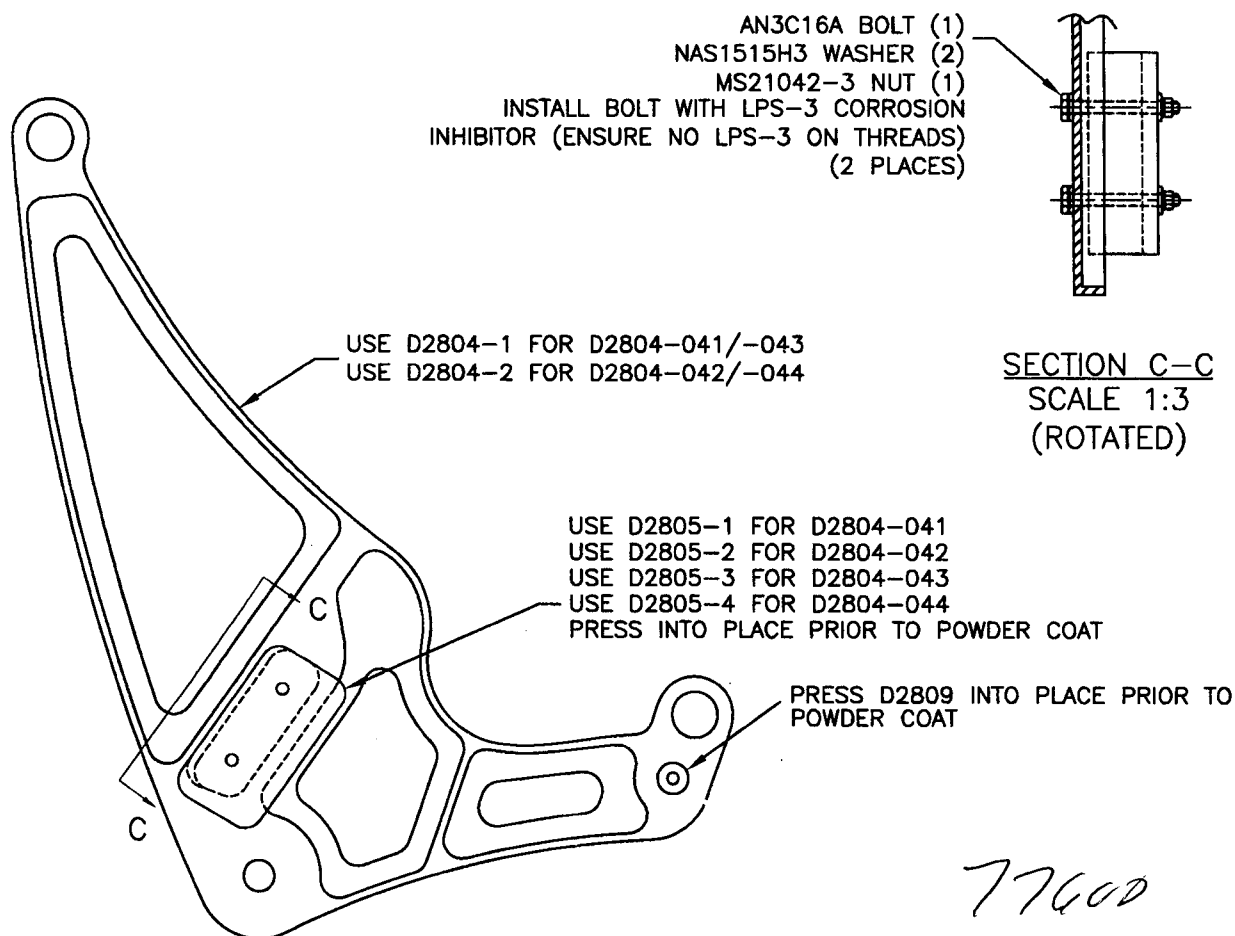
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C
SCALE 1:3
(ROTATED)

RELEASED

06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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H:\FORMS\Quality Assurance\approved QANCRWO RevE